

Date: Friday, 9/1/2006 12:16:49 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 28400	
Estimate Number : 10512	
P.O. Number : <i>N/A</i>	Part Number : D26511
This Issue : 9/1/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2651 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28251	Material : <i>N/A</i>
Written By : _____	Due Date : 9/25/2006
Checked & Approved By : <i>[Signature]</i> 06 09.01	Qty: <i>300</i> Um: Each
Comment : Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0421 f(s)/Unit Total: 12.6315 f(s)  
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia  
 (M6061T6R0500)  
 Batch: *m101421*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



*Issue P.O. 2057*



*0609/06*  
*300*

Comment: HAAS CNC VERTICAL MACHINING #1  
 1- Turn as per Folio FA219 and Dwg D2651 *turn per dwg D2651 Rev B*  
 2- Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*RG*



*Receive + Inspect*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*for transit damage 06/10 300*

4.0	QC3	SECOND CHECK
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Comment: SECOND CHECK

*Inspect level 5* *06-09-18*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651

*N/A 0609/18*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PL Date: 06/09/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/1/2006 12:16:49 PM  
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Job Number: 28400

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*A.M. 06-09-19*

*(300)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Only larger section necessary)

*FC 06 09 20 (304)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*A.M. 06-09-20*

*(304)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FPIS*

*FC 06 09 20 (304)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06-09-20*

Job Completion



*u 06-09-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

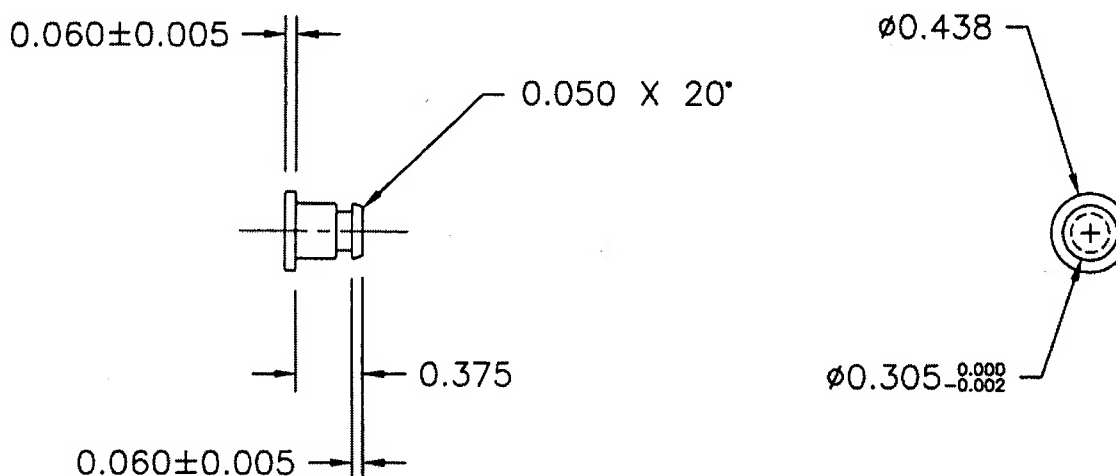


DESIGN A	DRAWN BY A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

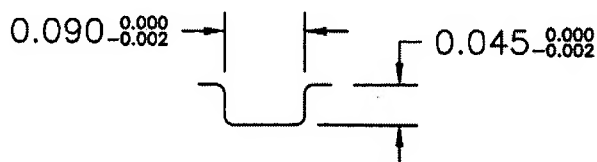
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28400

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

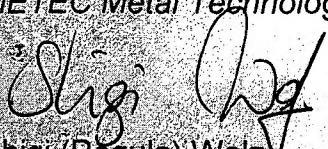
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
358	D2649	Cross Bolt Spacer	M100704	Linda
155	D2649	Cross Bolt Spacer	M19051	Linda
606	D2651-1	Plug	M101421	Linda
200	D2743	Cross Bolt Spacer	M100451	Linda

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz

Vankleek Hill, September 15, 2006